

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019639**Date Inspected:** 22-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**WELDING**

This QA Inspector observed the following work in progress:

**BAY 14**

This QA Inspector observed ZPMC qualified welding personnel identified as 066163 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013P-058. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Critical welding repair report B-CWR2719.

This QA Inspector observed ZPMC qualified welding personnel identified as 045221 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013AH-024, 025. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR20171.

This QA Inspector observed ZPMC qualified welding personnel identified as 066002 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013AH-041 ~

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

044. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20173.

This QA Inspector observed ZPMC qualified welding personnel identified as 067949 perform repair welding by Flux Cored Arc Welding (FCAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-037. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair-FCM and Critical welding repair report B-CWR2752.

This QA Inspector observed ZPMC qualified welding personnel identified as 066236 perform repair welding by Flux Cored Arc Welding (FCAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-019. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-FCAW-2G (2F)-ESAB-Repair-FCM and Critical welding repair report B-CWR2752.

This QA Inspector observed ZPMC qualified welding personnel identified as 066038 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020BB-010. ZPMC Quality Control (QC) Inspector identified as Li Ming Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair-1 and welding repair report B-WR20164.

This QA Inspector observed ZPMC qualified welding personnel identified as 066398 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 14W. Weld joint is identified as SEG3020Q-058. ZPMC Quality Control (QC) Inspector identified as Li Ming Yang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and Critical welding repair report B-CWR2620.

This QA Inspector observed ZPMC qualified welding personnel identified as 066163 perform repair welding by Shielded Metal Arc Welding (SMAW), on OBG Segment 13AW. Weld joint is identified as SEG3013D-235. ZPMC Quality Control (QC) Inspector identified as Zhang Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-3G (3F)-FCM-Repair-1 and welding repair report B-WR20172.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

No relevant conversations.

### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372 , who represents the Office of Structural Materials for your project.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

---

**Inspected By:** Upadhye, Anand

Quality Assurance Inspector

---

**Reviewed By:** Clifford, William

QA Reviewer